

# Work Order ID 50766

July 22, 2009 6:55:16 AM



Page 1

Item ID: D3296-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Door Panel

Start Date: 7/22/09 Start Qty: 20.00



Cust Item ID:

Required Date: 7/31/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *09-08-11*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3296

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3296 11Dwg Rev: A 11Prog Rev: A 12-  
Deburr if necessary

HB 9-7-09

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 9-7-09

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) S or 10/10

ccenter  
221 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50766

July 22, 2009 6:55:16 AM

Page 2

Item ID: D3296-3  
Revision ID: A  
Item Name: Door Panel

Accept

Setup Start  
Stop

Start Date: 7/22/09 Start Qty: 20.00  
Required Date: 7/31/09 Req'd Qty: 20.00

Cust Item ID:  
Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start  
Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo  
Debur

a / 7 S

0.00

0.00

done 2/10

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

=> 09-07-29 (K21) JH

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BL 09-07-29 (21)

W/O:		WORK ORDER CHANGES					
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# Work Order ID 50766

July 22, 2009 6:55:16 AM

Page 3

Item ID: D3296-3  
Revision ID: A  
Item Name: Door Panel

Accept

Setup Start  
Stop

Start Date: 7/22/09 Start Qty: 20.00  
Required Date: 7/31/09 Req'd Qty: 20.00

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: Date:  
QC: Date:

Tooling: Date:  
SPC (Y/N): Date:

Run Start  
Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: 186

0.00



Packaging

Memo

0.00

Packaging

12/9/30 (21)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

650811

W 31.08.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

July 22, 2009 6:55:15 AM

Work Order ID: 50766

Parent Item: D3296-3RevA

Parent Item Name: Door Panel


Comments:

Start Date: 7/22/09

Required Date: 7/31/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	158.6888	13.7516	21		6876 per unit
												
2024-T3 .063 sheet												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

158.6888421

102942	1.5
105916	3.69
106223	1.47
109463	24.2
110980	15.45
111787	110.378842
19059	2

110347 *21* ✓

~~107942~~

109463 X 4  
110980 X 4  
111787 X 6

110347 X 7

B 9-7-09

(21)

W/O:		WORK ORDER CHANGES					
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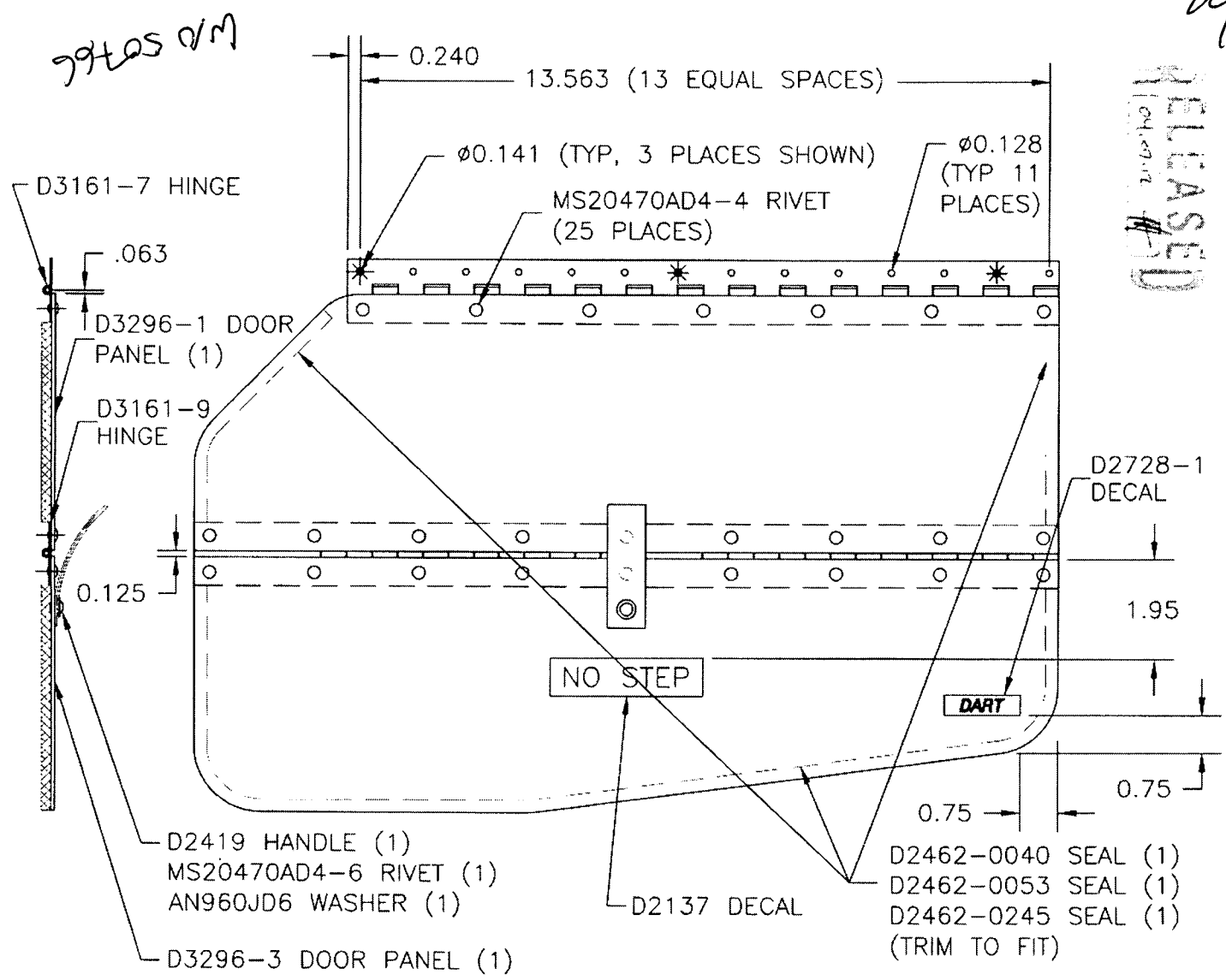


W/O 50766



RELEASED  
04.07.2

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296
DATE 04.06.28	TITLE DOOR ASSEMBLY	REV. A 1 OF 2
A	04.06.28	NEW ISSUE
		SCALE 1:3



- D3296-041 DOOR ASSEMBLY**
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
  - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
  - 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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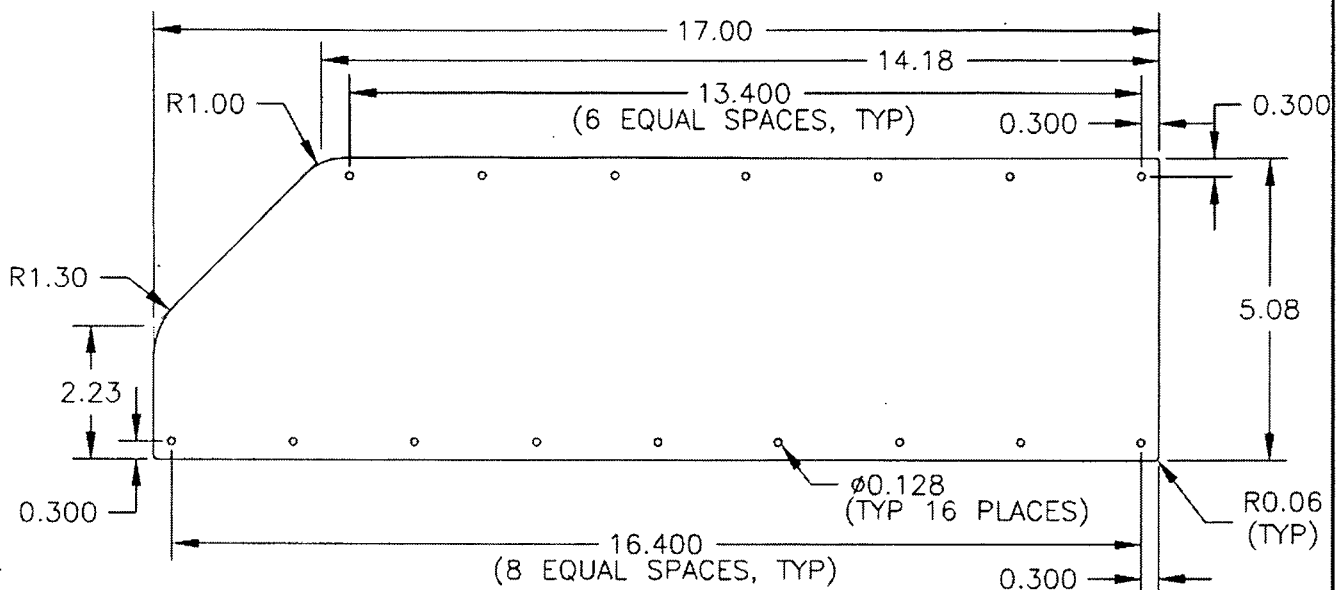
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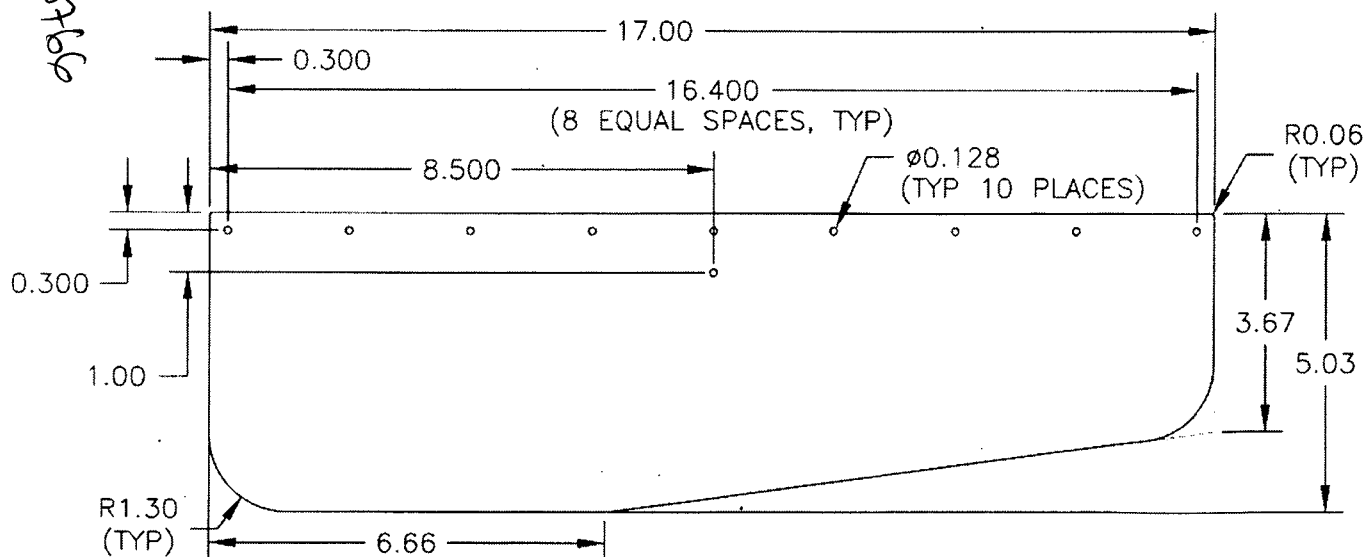
**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



**D3296-1 DOOR PANEL**



**D3296-3 DOOR PANEL**

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
04.07.12

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